

Work Order ID 60902

Page 1

Monday, July 26, 2010 2:12:31 PM

Item ID: K642-512

Accept



Setup Start



Revision ID:

Item Name: saddle kit 642-512

Stop



Start Date: 7/26/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-7-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Create White labels per PPP K642-512 CHG004

8/08/13

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/8/11 (12) 4/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept



Setup Start



Revision ID:

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Stop



Start Date: 7/26/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC4- 100% Inspect kits for completeness

Set Up/
Run Hours

0.00

0.00

S. W. S. 16

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Packaging

0.00

0.00

Identify and pack for shipping as per PPP K642-512 Location: PK

RCA

10/08/17 sf 30

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/17 J

MF 10-8-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 60902



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Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 05.06.07 new issue EC
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C35A  S+3 BOLT		Purchased	No			110	Each	80.0000	3	9	10/8/12	S	

Location	Loc Qty	Loc Code
ST353	80	
111724	1	
112489	49	
114523	30	

AN3C36A  S+3 BOLT	Purchased	No			110	Each	41.0000	9	27	17	M115358	10/8/12	S
---	-----------	----	--	--	-----	------	---------	---	----	----	---------	---------	---

Location	Loc Qty	Loc Code
ST353	41	
101261	4	
106541	6	
114653	31	

AN3C41A  S+3 BOLT	Purchased	No			110	Each	117.0000	8	24	10/8/12	50	23	
---	-----------	----	--	--	-----	------	----------	---	----	---------	----	----	--

Location	Loc Qty	Loc Code
FG	4	
103324	4	
ST354	113	
108084	8	
112829	5	
114443	100	

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60902



Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

110

Each

419.0000

12



36

10/8/12 sf

S
+3
Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

FG	4	
103344	4	
ST356	415	
113121	215	30
115016	200	

AN5C11A

Purchased

No

110

Each

236.0000

8



24

10/8/12 sf

S
+3
Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

FG	4	
104817	4	
ST338	232	
114443	62	24
114455	70	
114523	100	

AN5C12A

Purchased

No

110

Each

88.0000

4



12

10/8/12 sf 30

S
+3

Location	Loc Qty	Loc Code
----------	---------	----------

FG	2	
18918	2	
ST338	86	
113121	86	12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60902



Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN5C13A



Purchased

No

110

Each

106.0000

4

12

10/18/12 SP

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
18918	2	
ST338	104	
107615	1	
111648	3	
113121	50	
114615	50	

AN5C15A



Purchased

No

110

Each

93.0000

1

3

10/18/12 SP

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST339	93	
111819	93	

AN5C32A



Purchased

No

110

Each

99.0000

2

3

10/18/12 SP 50

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	4	
18918	4	
ST340	95	
110155	4	
111808	41	
113164	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN5C34A

Purchased

No

110

Each

112.0000

2

6

10/12/12 SP

S73

Location	Loc Qty	Loc Code
FG	2	
18918	2	
ST340	110	
111648	50	6
112454	60	

AN5C35A

Purchased

No

110

Each

97.0000

1

3

10/12/12 SP

S73

Location	Loc Qty	Loc Code
ST340	97	
107551	1	
108084	50	3
108407	46	

AN960C10L

NAS1149C0332

Purchased

No

110

Each

29.0000

24

72

1115000 10/12/12 SP 3x

S73



washer

Location	Loc Qty	Loc Code
ST245	29	
107534	29	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60902



Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN960C416L



Purchased

No

110

Each

820.0000

24

72

10/8/11 sf

S+3

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	44	
104925	44	
ST346	776	
106785	38	
107008	10	
112794	287	72
112828	400	
69220	41	

AN960C516L

NAS1149C0532

Purchased

No

110

Each

6.0000

8

24



1114348 10/8/11 sf

S+3

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST347	6	
111916	6	

D206-648-013



Manufactured

No

110

Each

1.0000

1

3

61048 10/8/11 sf

S+3

GHW Modification

4167002

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG120	1	
59234	1	

B61238 2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60902



Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2652



Bushing

Manufactured

No

110

Each

249.0000

16

48

10/18/10 111
B6119711x
10/18/10 usd

D2712



Set Screw

Manufactured

No

110

Each

203.0000

10

30

10/18/10 50

D2932-2



Saddle RH Out, 206

Manufactured

No

110

Each

13.0000

1

3

10/18/11 30
S230

Location

Loc Qty

Loc Code

ST421

3

53329

3

ST428

10

58266

4

60253

6

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 60902



Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2933-2

Manufactured No

110

Each

5.0000

1

1/3

1



Sf Saddle RH In, 206

60902

10/8/11 SP

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST428	5	
52587	2	
53330	3	

D2934

Manufactured No

110

Each

70.0000

2

1

6
10/8/11 SP

Sf Saddle Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	6	
31929	6	
ST031	64	
59641	64	

D2935

Manufactured No

110

Each

56.0000

2

1

6
10/8/11 SP

Sf Saddle Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST028	45	
59642	45	
ST031	11	
50211	11	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 60902



Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2938-2

Manufactured No

110

Each

8.0000

1

3

10/8/11 51



Saddle RH Out, 206

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST421	3	
53332	3	
ST428A	5	
58269	1	
58533	4	

D2939-2

Manufactured No

110

Each

7.0000

1

3
2
60906
10/8/11 51



Saddle RH In, 206

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST428A	7	
53334	3	
58268	1	
58535	3	

D3396-3

Manufactured No

110

Each

43.0000

2

6
3
10/8/11 51
34



Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	10	
26772	10	
ST055	33	
36336	2	
58680	31	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 60902



Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D3407-043

Manufactured No

110

Each

38.0000

1

3

S
Tow Ring



10/8/11 sf

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST464	38	
50176	6	
<u>50387</u>	20	
53351	12	

D3456-1

Manufactured No

110

Each

53.0000

1

3

S
B
Washer



10/8/11 sf

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST058	53	
<u>54692</u>	53	

Manufactured No

110

Each

63.0000

2

6

S
B
Washer



10/8/11 sf 3t

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	10	
32409	10	
ST059	53	
45913	2	
<u>52981</u>	51	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D3672-1



Phenolic Washer

3

Manufactured	No	110	Each	1,015.000	24	72
--------------	----	-----	------	-----------	----	----

10/8/11 SP

D3672-3



Phenolic Washer

3

Manufactured	No	110	Each	750.0000	24	72
--------------	----	-----	------	----------	----	----

10/8/11 SP

D3672-7



Phenolic Washer

3

Manufactured	No	110	Each	676.0000	24	72
--------------	----	-----	------	----------	----	----

10/8/11 SP

MS21043-3



3

Purchased	No	110	Each	2,985.000	20	60
-----------	----	-----	------	-----------	----	----

10/8/11 SP (30)

Location	Loc Qty	Loc Code
ST077	997	
51674	5	
52505	992	34
ST117	18	
34470	18	18
ST077	750	
57704	750	
ST077	676	
53237	676	
ST301	2909	
103691	76	
107280	4	
112314	2905	

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

MS21043-4



Purchased

No

110

Each

1,220.000

13

39



10/8/11 sf

S
23

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
104603	40	
ST301	1180	
112492	25	
113069	8	
114348	347	39
114523	500	
114784	300	

MS21043-5



Purchased

No

110

Each

612.0000

4

12



10/8/11 sf 30

S
23

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST301	612	
111819	112	10
112314	500	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
1	1	X				D206-642-541	SKIDTUBE
			X			D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
1	1			X		D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP (1)
4			2			AN3C4A	* BOLT (1)
5A			2			AN960C10L	* WASHER (1)
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) (1)
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT (2)
14	4	4				AN5C11A (or AN5C13A)	* BOLT (2)
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A		9	9			D3537-1	* WEARPAD (1) (REPLACES D2648-3)
21A		1	1			D3537-3	* WEARPAD (1) (REPLACES D3429-1)
22A		1	1			D3535-15	* WEARSHOE (1) (REPLACES D2656-15)
22B		1	1			D3536-15	* GASKET (1)
23A		1	1			D3535-23	* WEARSHOE (1) (REPLACES D2656-23)
23B		1	1			D3536-23	* GASKET (1)
24A		1	1			D3535-39	* WEARSHOE (1) (REPLACES D3287-1)
24B		1	1			D3536-39	* GASKET (1)
25A		1	1			D3535-35	* WEARSHOE (1) (REPLACES D2656-35)
25B		1	1			D3536-35	* GASKET (1)
26A		78	78			AN3C4A	BOLT (1)
26B		78	78			AN960C10L	* WASHER (1)
26C			78			ALS7-1032-130	* INSERT (1) (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE

(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)